

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018233**Date Inspected:** 21-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 007438

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment. The weld designations reviewed are as follows:

1. SEG3019AY-004

Ultrasonic Testing (UT) – NWIT Document No: 007440

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment. The weld designations reviewed are as follows:

1. SEG3014L-196, 197, 198, 202, 203, 199, 205, 237
2. SEG3014L-216, 217, 219, 222, 224, 218, 223, 245
3. SEG3015N-227, 228, 229, 233, 237, 230, 238, 234
4. SEG3015N-255, 256, 257, 261, 251, 258, 262, 252

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5. SEG3014D-225

Bay 16

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of welds joint BP3050-001- 065 and 066 located on bottom plate stiffener of OBG Segment. ZPMC Welders are identified as 2018888 and 066479. ZPMC Quality Control (QC) is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

Flux Core Arc Welding (FCAW) welding of welds joint BP3101-001- 021 and 022 located on bottom plate stiffener of OBG Segment. ZPMC Welders are identified as 2018888 and 066479. ZPMC Quality Control (QC) is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of welds joint AP3001-001-061 and 062 located on anchor plate stiffener of OBG Segment 14E. ZPMC Welder is identified as 062782. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of welds joint AP3001-001-081 and 082 located on anchor plate stiffener of OBG Segment 14E. ZPMC Welder is identified as 044824. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of welds joint AP3003-001-147 and 148 located on anchor plate stiffener of OBG Segment 14E. ZPMC Welder is identified as 066155. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of welds joint AP3003-001-161 and 162 located on anchor plate stiffener of OBG Segment 14E. ZPMC Welder is identified as 062782. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of welds joint AP3004-001-098and 099 located on anchor plate stiffener of OBG Segment 14E. ZPMC Welder is identified as 062782. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of welds joint AP3004-001-112 and 113 located on anchor plate stiffener of OBG Segment 14E. ZPMC Welder is identified as 044824. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
